

## **IN THE CLAIMS**

Please cancel claims 1-31, all of the claims in the subject U.S. patent application, as filed, as constituted by the verified translation of PCT/EP2005/050182. Please also cancel claims 1-36 filed by KBA under Article 34 on November 9, 2005.

Please add new claims 37-70, as follows.

### **Claims 1-36 (Cancelled)**

37. (New) A method for storing unprepared and prepared rolls of material for use by a material-processing machine including:

- providing a material flow system;

- providing an implemented logic device in said material flow system;

- providing said material flow system with information regarding one of a prognosis of use data for a pending production period to be examined by said material-processing machine and use data derived by prognosis;

- determining an actual stock on hand in said depot; and

- determining, in a first partial process of said material flow system, a storage strategy using said data obtained by prognosis and said actual stock on hand.

38. (New) The method of claim 37 further including considering criteria for a degree of use of storage in said depot in said printing production period to be examined.

39. (New) The method of claim 37 further including considering criteria for an

intended length of storage time of fresh rolls of said material during said production period to be examined.

40. (New) The method of claim 39 further including determining said storage strategy including considering criteria for an intended length of storage time of fresh rolls during said production period to be examined.

41. (New) The method of claim 37 further including considering an effectiveness of a glue preparation of said rolls of material during said planned production period.

42. (New) The method of claim 37 further including providing a first shelf block remote from said material-processing machine in said depot, providing a second shelf block adjacent said material-processing machine and providing an inner shelf block located between said first shelf block and said second shelf block.

43. (New) The method of claim 42 including, in a low storage application utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of prepared rolls and maintaining said inner shelf block empty except for passage of said rolls.

44. (New) The method of claim 42 including, in one of a normal storage and a high storage application, utilizing said first shelf block for storage of only unprepared rolls, utilizing said second shelf block for storage of only prepared rolls and utilizing said inner

shelf block as a buffer for unprepared rolls and for prepared rolls.

45. (New) The method of claim 37 further including considering criteria of a type of said rolls of material needed in said production period to be examined and further including differentiating in said type of said rolls of material needed between many small productions and fewer large productions.

46. (New) The method of claim 45 further including reserving sufficient space in said depot for the return of used rolls to said depot when said production period includes said many small productions.

47. (New) The method of claim 45 further including storing said prepared rolls in a travel optimized manner when said production period includes said fewer large productions.

48. (New) The method of claim 37 further including, in a second partial process, checking an occupancy of said depot and positioning of said prepared and unprepared rolls in said depot in a manner optimized for production, and determining a strategy for repositioning said prepared and unprepared rolls in said depot using criteria for a degree of storage use to be expected during said production period under examination.

49. (New) The method of claim 48 further including providing said material flow system with information regarding an actual stock of said rolls of material on hand.

50. (New) The method of claim 49 further including determining a strategy for a production-oriented repositioning in said depot using criteria for an extent of depot occupancy during said production period to be examined.

51. (New) The method of claim 50 further including providing roll changers in said material-processing machine and considering an extent of occupancy of said depot whenever, in low occupancy, storage of said prepared rolls is taking place in a path-optimized manner with respect to one of said roll changers to be severed and wherein, in high occupancy, storage of said prepared rolls is taking place chaotically in said depot acting together with active ones of said roll changers.

52. (New) The method of claim 42 further including providing a first serving element remote from said material-processing machine and locating said first serving element between said first and third shelf blocks, and further including providing a second serving element adjacent said material-processing machine and locating said second serving element between said second and said inner shelf blocks.

53. (New) The method of claim 52 further including locating ones of said prepared rolls required for use within a short time in one of said second and said inner shelf blocks.

54. (New) The method of claim 52 further including redepositioning unprepared ones of said rolls of material for preparation of said rolls of materials in an access area of

said second serving element.

55. (New) The method of claim 37 further including providing a roll preparation circuit in said depot and processing said unprepared rolls in said roll preparation circuit.

56. (New) The method of claim 54 further including providing a roll preparation circuit in said depot and removing unprepared rolls from one of said first shelf block and said inner shelf block, using one of said serving elements, and supplying said unprepared rolls to said roll preparation circuit.

57. (New) The method of claim 56 further including placing said rolls of material, after passage through said roll preparation circuit, into intermediate storage in said inner shelf block.

58. (New) The method of claim 42 further including storing said rolls of material in one of said first shelf block and said inner shelf block as a result of a storage distance from a first partial process.

59. (New) The method of claim 42 further including delivering a prepared roll of said material from one of said first storage block and said inner storage block to a storage space in said second shelf block as a result of a storage demand from a partial process.

60. (New) The method of claim 50 further including categorizing a degree of occupancy of said depot below 40% as low occupancy.
61. (New) The method of claim 50 further including categorizing a degree of occupancy of said depot above 70% as high occupancy.
62. (New) The method of claim 38 further including storing said criteria in exact and changeable definition.
63. (New) The method of claim 38 further including storing said criteria in a form of a changeable term of a linguistic variable of a fuzzy logic control.
64. (New) The method of claim 37 further including providing one of a computing and a data processing unit in said material flow system and forwarding one of production-relevant data and use data regarding planned production of a production planning system to said one of said computing unit and said data processing unit.
65. (New) The method of claim 64 further including determining a storage strategy and a deposit request for said unprepared rolls of material using said one of said computing unit and said data processing unit using prognostic use data for a pending production period and information regarding an actual stock of said rolls of material, and further including fixing a time for a production preparation of said rolls of material in a preparation circuit using a logical device in said material flow system and considering

a limited shelf life of a glue preparation and a planned length of a production time.

66. (New) The method of claim 64 further including directing a partial signal requesting rolls of material to said material flow system, registering said partial signal in said one of said computing unit and said data processing unit and determining said partial signal using existing data regarding depot occupancy for availability in said depot and ordering removal in response to said request directly through said material flow system.

67. (New) The method of claim 64 further including checking a partial request using said material flow system, using transmitted production-relevant data, for optimally positioning said prepared and unprepared rolls in accordance with planned production requirements, and further including determining a strategy for a production-oriented repositioning of said unprepared and prepared rolls in said depot.

68. (New) The method of claim 67 further including providing a logical device in said material supply system and using said logical device for performing said partial request.

69. (New) The method of claim 37 further including providing storage spaces in said depot for storing said unprepared and prepared rolls of material, continuously checking an occupancy of said depot in respect to planned requirements using a predetermined criteria and positioning said unprepared and prepared rolls of material in said storage spaces in a production-optimized manner.

70. (New) The method of claim 69 further including determining said storage strategy using prognosis of use data and information regarding actual stock on hand.